

Work Order ID 75079

75079

Page 1

October-17-11 10:50:48 AM

Item ID: D2803-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 17/10/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 08/11/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/17 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2803	Rev B

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100 FLOW WATER JET
 Waterjet
 FLOW CNC Waterjet
 6061 .500 X 10"
 Memo
 1-Cut as per FILE D2803-1
 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary
 11-11-11
 (8)

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110 HAAS CNC VERTICAL MACHINING #1
 HAAS I
 HAAS CNC vertical machine #1
 Memo
 Machine as per folio FA102
 11-11-17
 11-11-11
 7 1970

120		0.00							
-----	--	------	--	--	--	--	--	--	--

120 QC2- Inspect parts off machine FAI/FAIB
 QC
 Quality Control
 Memo
 11-11-17
 7 1

W/O:		75079 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2803-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: ✓ Date: 11/11/24
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/11/24

NCR:		11-1007 WORK ORDER NON-CONFORMANCE (NCR) 09.92						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-11-17	110	1 part c-bore is .513 instead of .507 ⁺⁰ _{-.001} RC: LVA operator error	11.11.18 Q51042	TIGHT TOLERANCE REQ'D ON BORE TO MINIMIZE POINT LOAD WHEN ACTUATOR IS ACTIVATED as INSTALL. 0.006" OVER TOLERANCE: SCRAP PART.	SL 11-11-17	S u/u/21	11.11.18 Q51042	S u/u/21

NOTE: Date & initial all entries

75079

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N900040100

Setup Start *NS1*

Stop *NS2*

8

Cust Item ID:

8

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75079

October-17-11 10:50:48 AM

N900040100

Setup Start *NS1*

Stop *NS2*

g

8

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00


0.00

Packaging

0.00

0.00

Quality Control

W/11/22 

mf
11-11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:50:53 AM

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Work Order ID: 75079

75079

Parent Item: D2803-1

D2803-1

Parent Item Name: Bracket

Start Date: 17/10/2011

Required Date: 08/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A00.11.06New IssueEC

IPP Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM

IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased		No		100	f	6.9249	1.9167	16.14063			

M6061T6B0 500X10 000

6061-T6 Bar .500 x 10.00

**

8 11-11-11

Location

Loc Qty

Loc Code

MAT004

6.9249

118271

6.9249

119346

119346

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	75079
Description: Bracket		Part Number:	D2803-1
Inspection Dwg: D2803 Rev: B		Page 1 of 1	

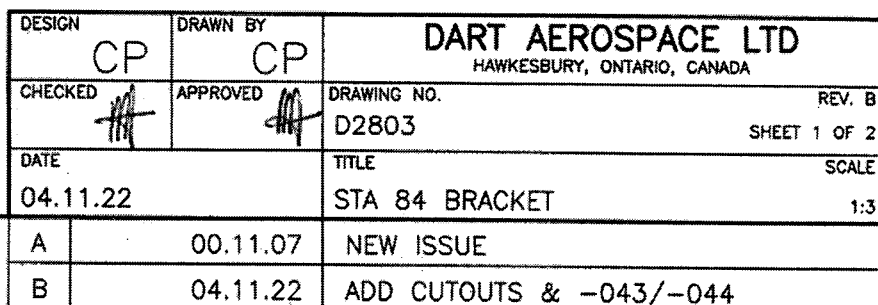
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

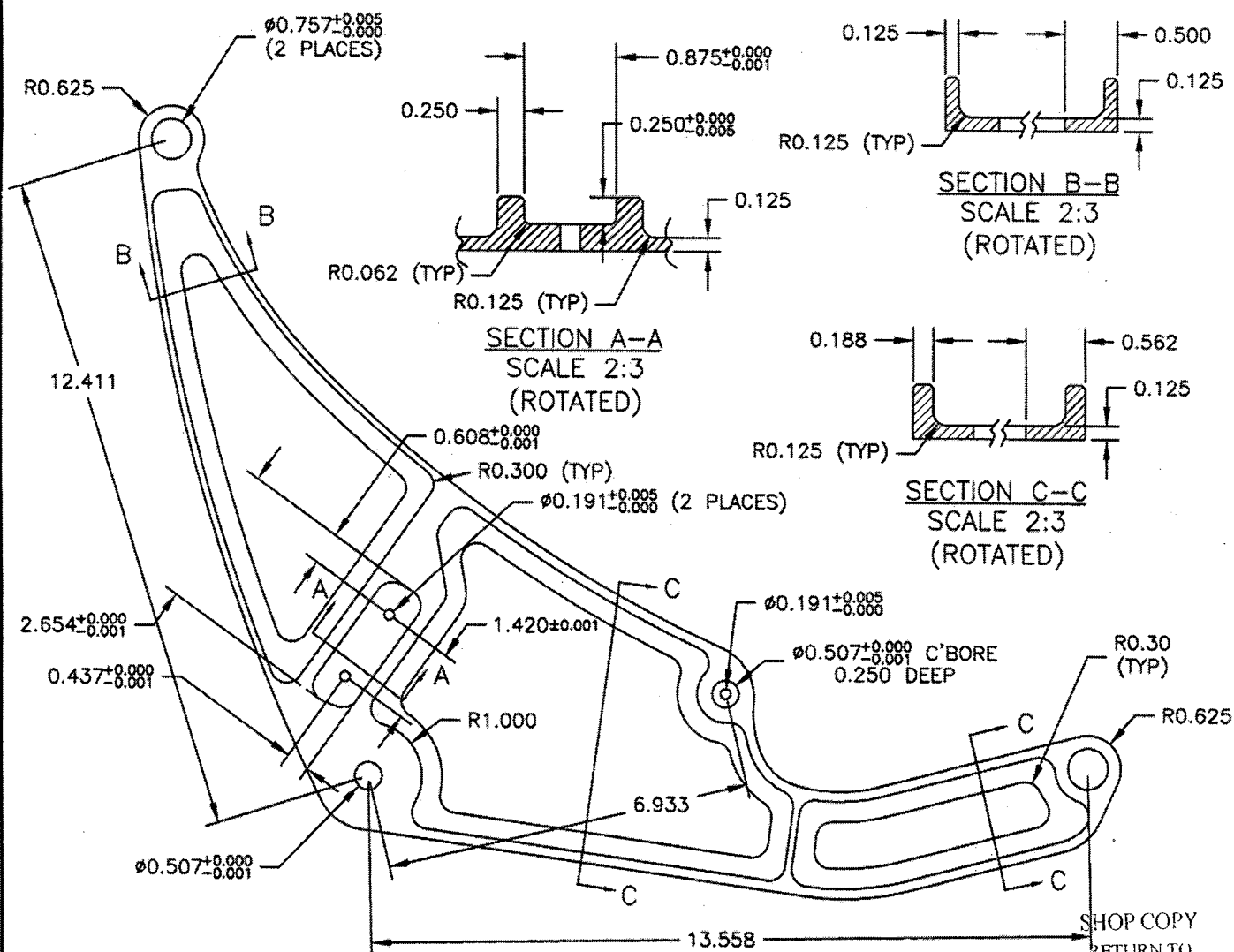
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.761	✓			
Ø0.191	+0.005/-0.000	.192	✓			
Ø0.507	+0.000/-0.001	.5062	✓			
13.558	+/-0.010	13.558	✓			
Ø0.507	+0.000/-0.001	.5062	✓			
12.411	+/-0.010	12.411	✓			
2.654	+0.000/-0.001	.26535	✓			
0.437	+0.000/-0.001	.437	✓			
1.420	+/-0.001	1.420	✓			
6.933	+/-0.010	6.933	✓			
0.250	+/-0.010	.250	✓			
0.875	+0.000/-0.001	.8745	✓			
0.250	+0.000/-0.005	.248	✓			
0.125	+/-0.010	.126	✓			
0.125	+/-0.010	.126	✓			
0.125	+/-0.010	.123	✓			
0.125	+/-0.010	.124	✓			
0.500	+/-0.010	.502	✓			
0.562	+/-0.010	.563	✓			
0.188	+/-0.010	.188	✓			

Measured by: SL	Audited by: H.A	Prototype Approval:	N/A
Date: 11-11-14	Date: 11/11/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM	FE



05.03.11



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 75079

NO 75079

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R/HQ-17

D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

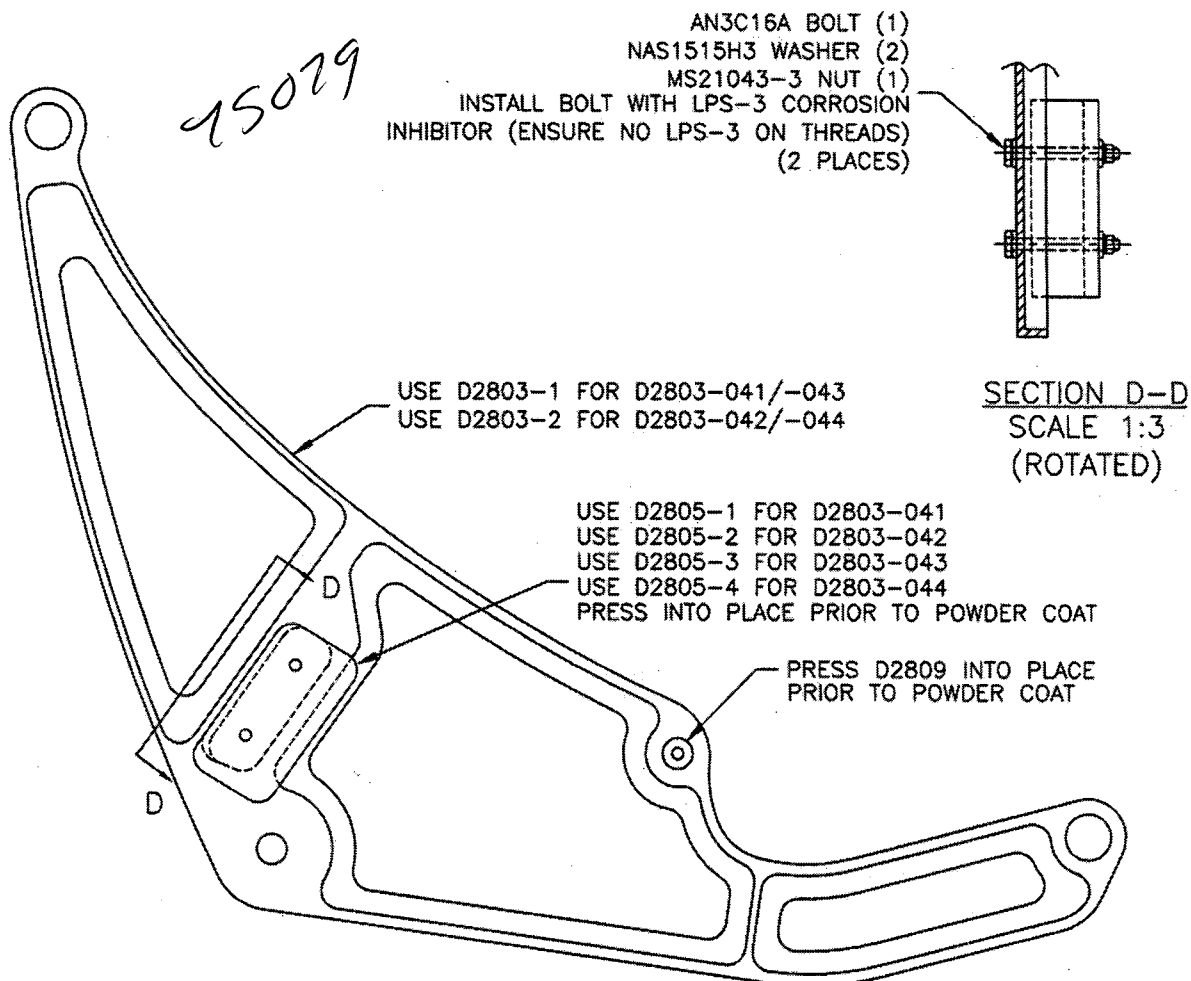
- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3



RELEASED

05-03-11 [Signature]

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDEX (4.3.5.6)
OR BLACK SANDEX (4.3.5.7) OR GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3

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